


Date: Thursday, 2/21/2008 9:28:28 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE	
Job Number : 37576	Part Number : D37301	
Estimate Number : 13169	Drawing Number : D3730 U/R	
P.O. Number :	Project Number : N/A	
This Issue : 2/21/2008 S.O. No. :	Drawing Revision : U/R	
Prsht Rev. : NC	Material :	
First Issue : 1 / Type : MACHINED PARTS	Due Date : 3/5/2008	Qty: 30 Um: Each
Previous Run : 37401		
Written By :		
Checked & Approved By :		
Comment : Est Rev: A 08-01-30 new issue DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6207	Angle Extrusion 1x1x.125
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M6061T6A0750W125 08/02/22



5.5968  
31  
32

Comment: Qty.: 0.1749 f(s)/Unit Total : 5.2479 f(s)  
D6207 angle extrusion  
Batch: M18147

080304  
080221

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: 1- Mill as per dwg D3730  
2-Deburr

080304  
080221

31  
32

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

080304  
080221

31  
32

4.0	QC8	SECOND CHECK
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080305



31  
32

Comment: SECOND CHECK

08/02/22

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3730

2- Deburr if necessary

080305  
FF 0802-27

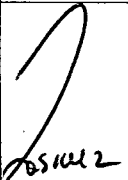

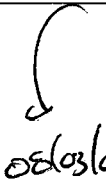
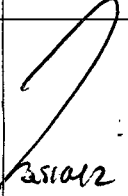
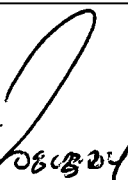
31  
32

2/6

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/03/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080304	S.O	All parts were deburred too deep, resulting in almost c'ringing the holes.  RC: Human error.		Scrap: Replace all Qty 432 B# M18147	 080304	 080304	 080304	 080304
				only 31 done.				

NOTE: Date & initial all entries

Date: Thursday, 2/21/2008 9:28:29 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 37576

Part Number: D37301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

ENGINEER  
APPROVAL

ASS



Comment: INSPECT WORK TO CURRENT STEP

~~08/03/06~~ 08/03/06 (31)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PR 08-03-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/03/06 (31)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Pat Evers call 08/03/10 (31)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/17 (31)

Job Completion



mi 2008/3/10 (31)

POSITIVE RECALL

EFFECTIVE 08.02.21 AUTH 14

RELEASED ASS DATE 08.03.17

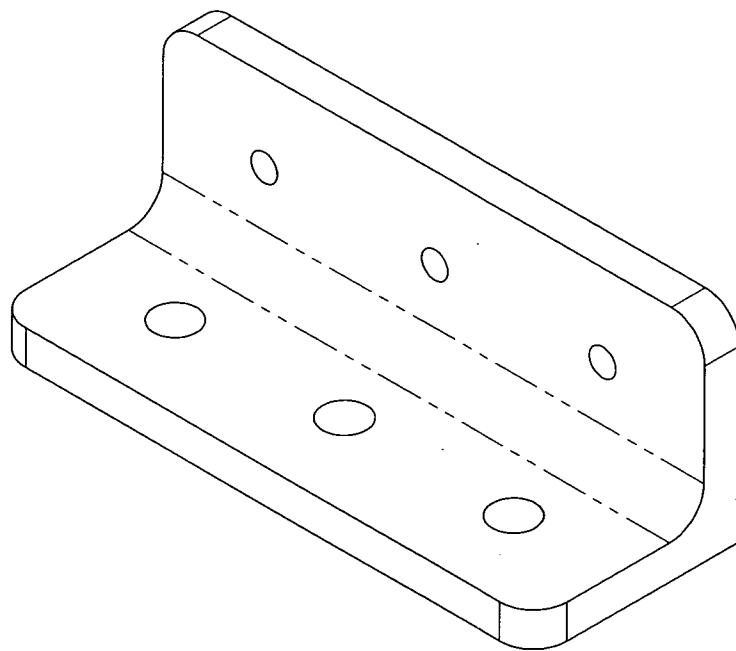
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



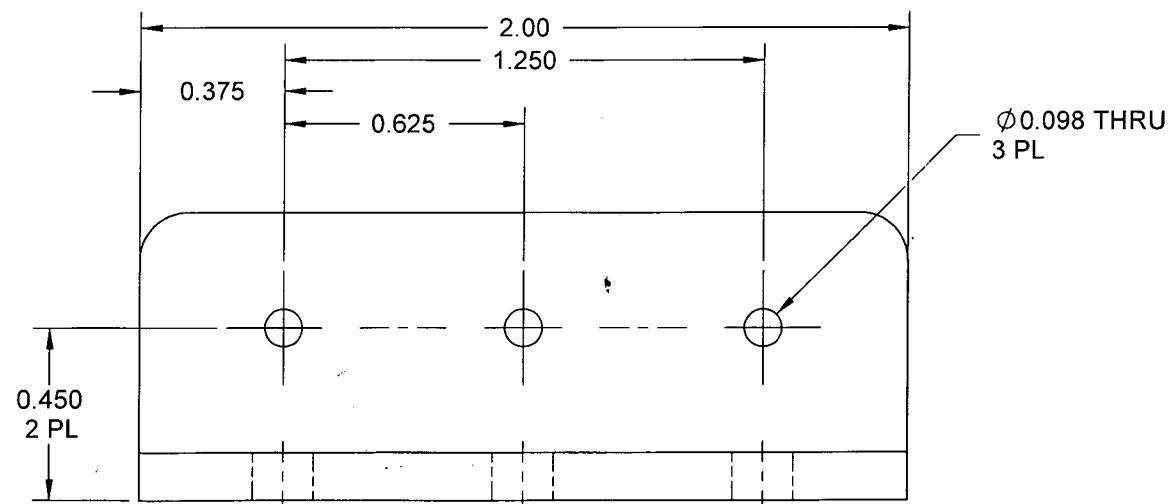
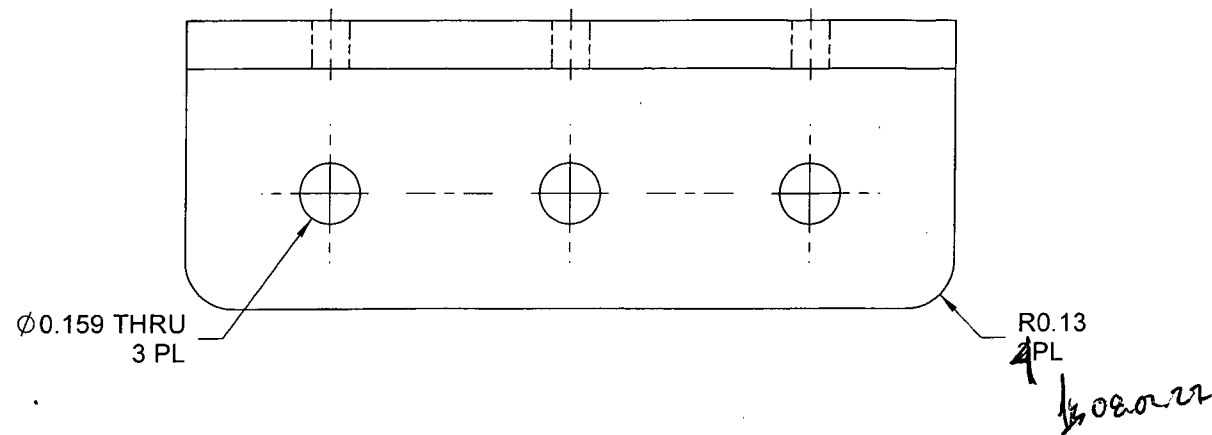
**D3730-1 ANGLE**

**PRELIMINARY ISSUE**  
AJS 02.21.08

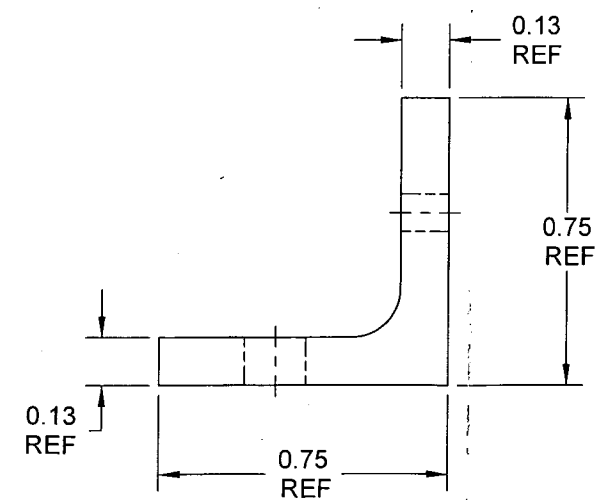
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WITHOUT NOTICE  
WORK ORDER  
NO. 37576

- NOTES:
- 1) MATERIAL: 6061-T6/T6510/T6511 ALU MINUM ANGLE, 0.75 X 0.75 X 0.125  
PER AMS-QQ-A-200/8  
(REF. DART SPEC. M6061T6A07500750T125)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.03 lbs

A	NEW ISSUE		AJS	08.01.31
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>MS</i>			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3730	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
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**D3730-1 ANGLE**

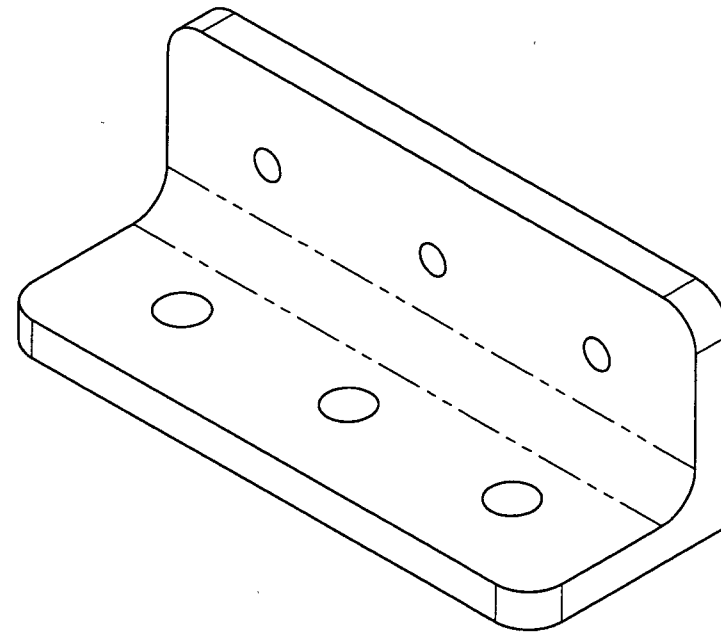


**PRELIMINARY ISSUE**  
AJS 02.21.08

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WORK ORDER  
NO. 37576


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MFG. APPR.		D3730	SHEET 2 OF 2
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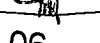




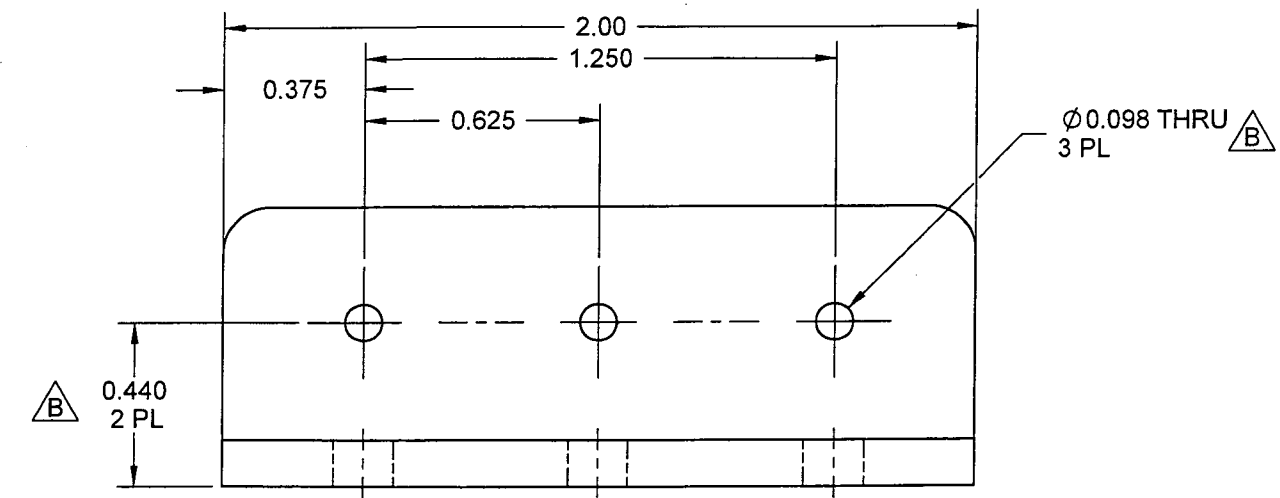
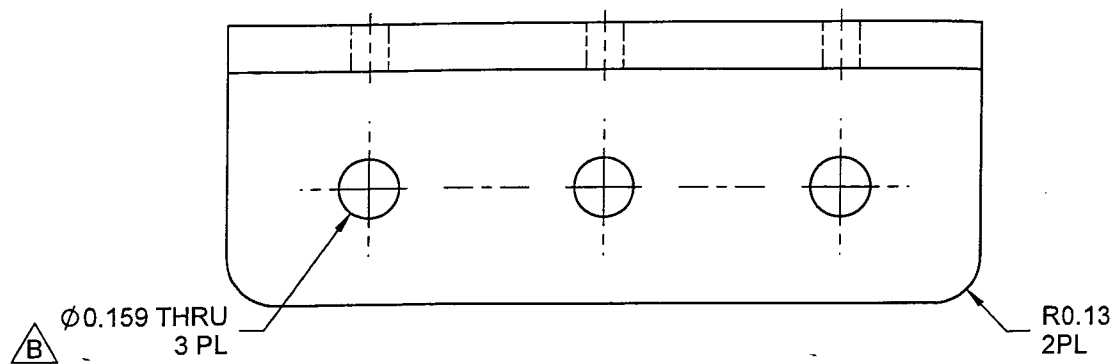
**D3730-1 ANGLE** 

**NOTES:**

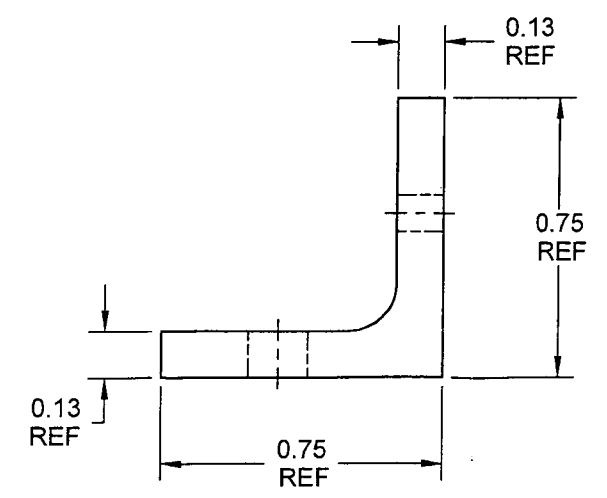
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125  
PER AMS-QQ-A-200/8  
(REF. DART SPEC. M6061T6A750XW125) 
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED. SHEET 2 ZONE C4, Ø0.098 HOLES WERE Ø0.159, ZONE 7B 0.440 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.01.31
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
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**D3730-1 ANGLE**



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